

DESCRIPTION

Under this item, the CONTRACTOR shall weld poles, plates, etc. in a manner described in the plans and/or specifications or as ordered by the ENGINEER.

MATERIAL AND METHOD

The following process shall be used for all welding unless other processes are approved on the basis of a procedural qualification test:

- a. Manual Shielded Metal-Arc Welding.
- b. Submerged Arc Welding.
- c. Flux Cored-Arc Welding with External Carbon Dioxide Gas Shielding.
- d. Electroslag Welding.

Details of Fillet. Joints shall be welded so as to minimize stress due to shrinking of the weld metal and adjacent base metal upon cooling. Parts to be joined by fillet welds shall be brought into as close contact as practical. The maximum gap between parts being jointed shall be 1.6mm. Before welding, all surfaces shall be cleaned to a bright clean metal surface. All previous deposited metal from previous weld passes shall have all the slag removed and the adjacent base metal brushed clean before additional welding takes place.

The CONTRACTOR shall furnish all the necessary welding materials required to perform the work, such as rods, metal brackets, braces, etc.

PERSONNEL QUALIFICATION

The only personnel allowed to perform any welding shall have been qualified by written performance tests as administered by the State of New York and the welder must hold a current certification card issued by the STATE.

MEASUREMENT AND PAYMENT

The lump sum bid price for welding shall include the furnishing of all labor, materials, and equipment necessary to complete the work in accordance with the plans, specifications, special notes and as specified by the ENGINEER.

Payment will be made under:

<u>Item No.</u>	<u>Item</u>	<u>Pay Unit</u>
686.01M	Welding	LS